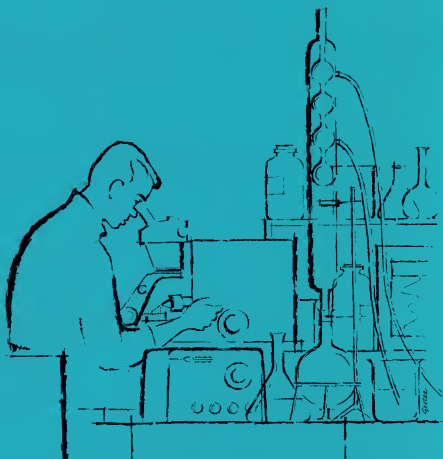


LKB 7800 KnifeMaker

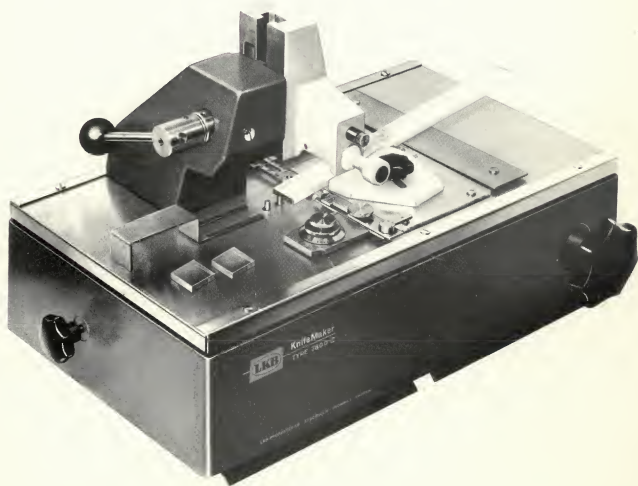
Spare Parts Catalogue



LKB - PRODUKTER AB

S-161 25 BROMMA 1 • SWEDEN

KnifeMaker LKB 7800



HOW TO USE THE CATALOGUE

General

This Catalogue has been prepared for users of LKB equipment:

- To help identify instrument components
- To provide all necessary information to enable spare parts to be properly ordered.

The main parts of the instrument are shown in figure 78-0
Sub-components are given on following pages.

This Catalogue does not provide a guarantee that all parts listed are in stock.

Stocks of those spares most frequently ordered are normally available.

When ordering bear in mind that even if the part required can be supplied immediately from stock, the shipping time must be taken into consideration.

How to Order

Clearly indicate the following information on your orders:

- A. Purchase order number.
- B. Total number of items ordered.
- C. Spare Part No. and Name of Part.
- D. Where the parts are to be sent.
- E. When you want the order shipped.
- F. Preferred means of transport.
- G. Any special shipping instructions.

Where to find the Information

- Column 1. "Spare Part No.": This refers to figure illustrating the particular part and its numerical designation in that figure. It is the number that should be used when ordering spares.
When Spare Part is designated by index (e.g. 20,1) This indicates it belongs to corresponding Spare Part with main designation only (e.g. 20)
- Column 2. "Name of Part.": A brief description indicating the part.
Figures in parenthesis refer to Adjustment and Maintenance Notes on page 19 and following pages.
- Column 3. "Catalogue No.": This number need not be used when writing orders for spares. It refers to the number included in the company price list.
- Column 4. "Internal No.": This number should not be used when ordering. It is an identification used by the drawing office and the production and marketing departments for internal administration. This number is included to assist us in giving you a better service.
- Column 5. Blank column. This can be used for your own notes, local prices or special remarks.

How to find a part when you do not know its number

1. Refer to the main assembly in which you consider the part is located.
2. If a further figure is mentioned, look up that figure and locate the Spare Part number accordingly.
3. Note the Spare Part number and Name of Part.

INDEX

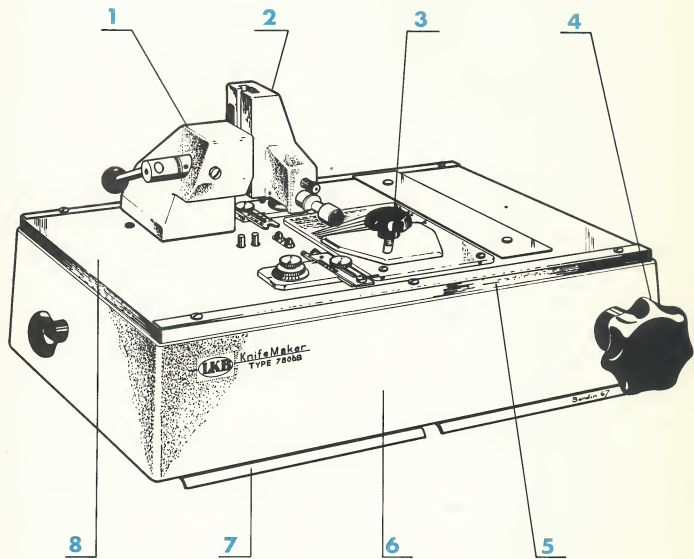
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MAIN ASSEMBLY

78-0

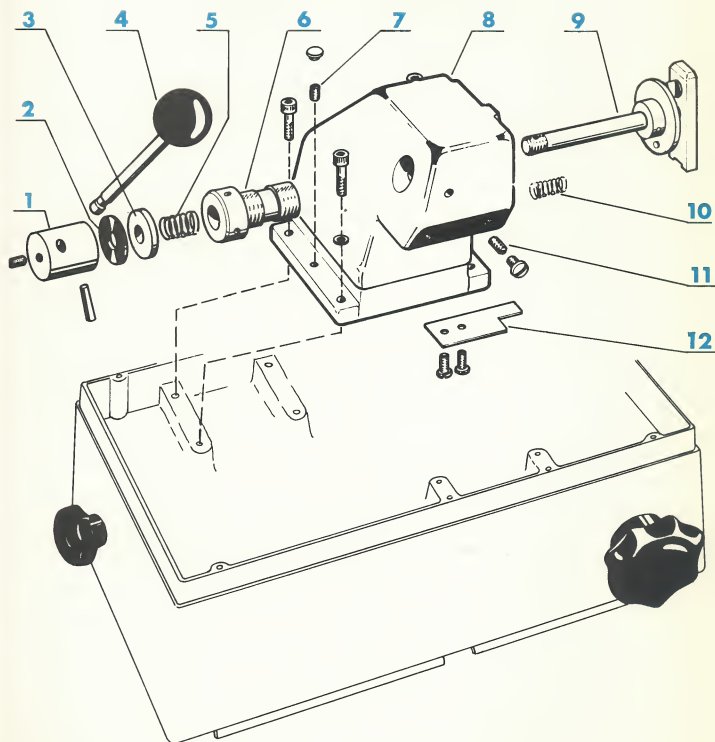
Spare Part No.	Name of Part	Catalogue No.	Internal No.	
78-0-0	Knife Maker	7801A	10-158, 04-10 740	
-1	Bracket See Figure 78-1		32-17 04, 04-10 737	
-2	Clamping head See Figure 78-2		13-22 48, 04-10 730	
-3	Glass Setting assembly See Figure 78-3			
-4	Breaking assembly See Figure 78-4			
-5	Cover strips		23-22 14	
-5,1	Screws		LKCS 4 x 8 fz	
-6	Base		22-17 02	
-7	Recess for "Operation Instruction"		14-10 632	
-7,1	Feet		Sthlm. Gummind. AB Nr. 35 75	
-7,2	Screws		EC5 4 x 25 fz	
-8	Cover plate		12-17 05, 04-10 757	



BRACKET

78-1

Spare Part No.	Name of Part	Catalogue No.	Internal No.
78-1-0	Bracket (6)		32-17 04, 04-10 737
-1	Hub		24-10 669
-1,1	Tapered pin		KP 3 x 24 PD 300 extr.
-2	Friction washer		24-11 139
-3	Washer		24-11 434
-4	Locking lever		14-10 670
-4,1	Lock screw		SK6SS 5 x 6 fz
-5	Spring		24-10 693
-6	Adjusting sleeve		24-10 667
-7	Set screw		SK6SS 5 x 8 fz
-7,1	Cover plug		Teleinvest. AB HV3442 grå
-8	Bracket head		23-22 53
-8,1	Screws		EC 6 x 25 fz
-8,2	Lock washers		BRB 6,4 x 12 fz
-9	Pressure assembly		34-10 665
-10	Spring		24-10 745
-11	Set screw		SK6SS 5 x 12 fz
-11,1	Cover screw		LKCS 5 x 5
-12	Leaf spring		24-10 686
-12,1	Screws		LKCS 3 x 8

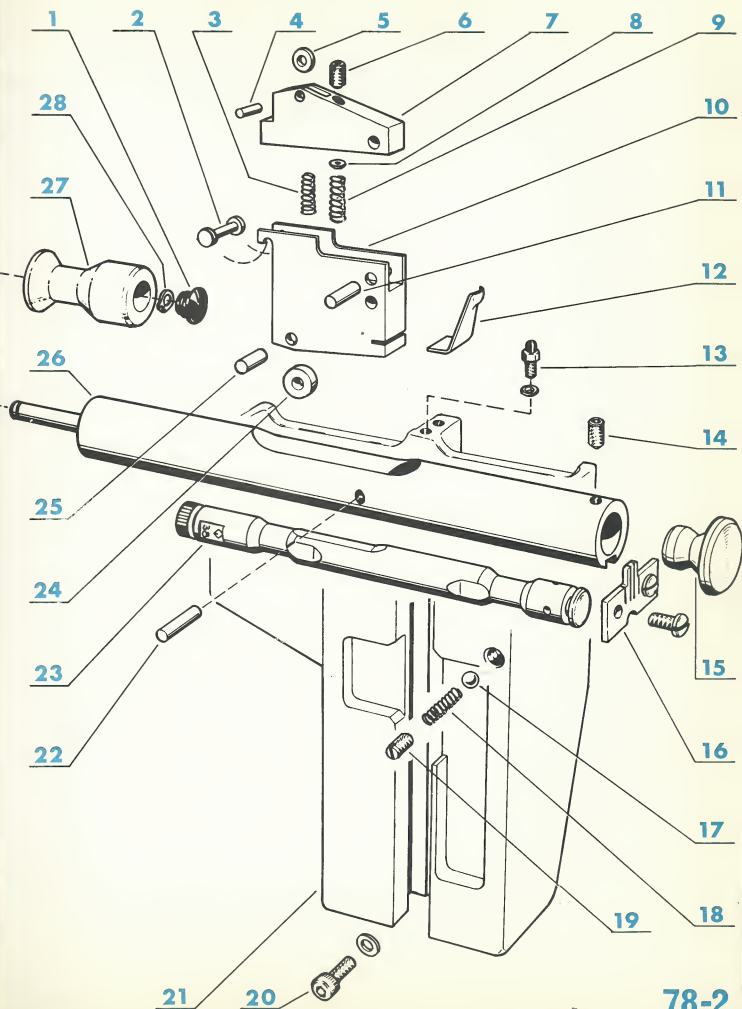


CLAMPING HEAD

(FIGURE IS SHOWN UPSIDE DOWN)

78-2

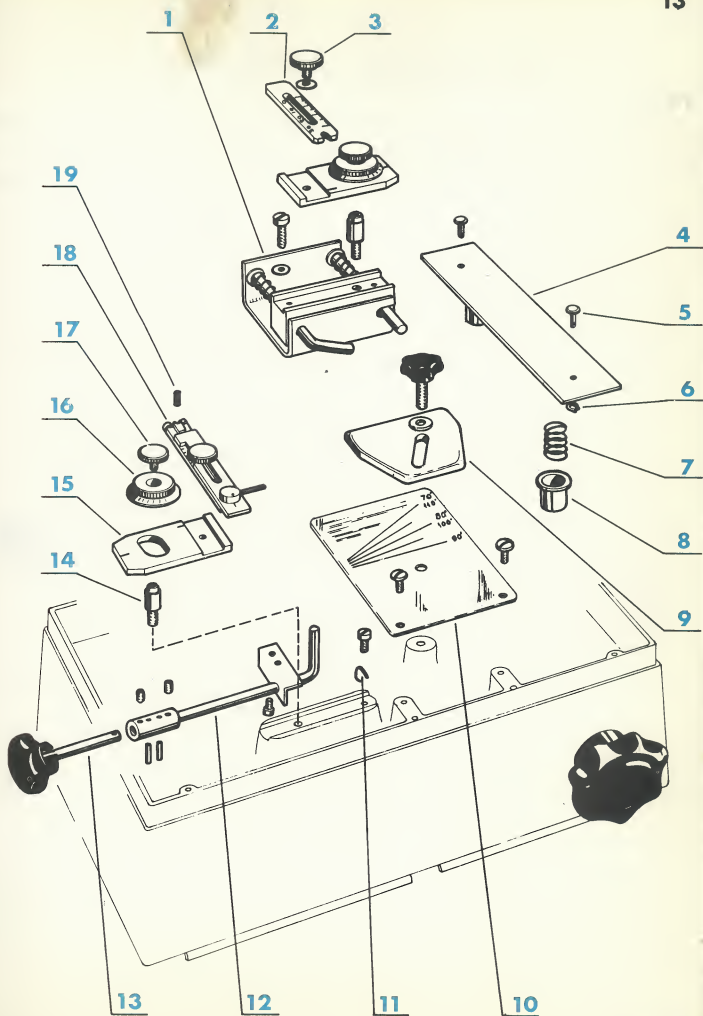
Spare Part No.	Name of Part	Catalogue No.	Internal No.
78-2-0	Clamping head		13-22 48, 04-10 730
-1	Cover disc		T Schouboe Nr:9111 svart
-2	Locking pin		24-10 692
-3	Spring		24-10 696
-4	Wheel shaft	7890-02	24-10 751, 04-10 882
-5	Cutter wheel (1)	7890-01	24-10 731, 04-10 882
-6	Pressure adjusting screw (3)		24-10 754
-7	Cutter wheel Holder		24-10 687
-8	Buffer piece		BRB 2,5 x 5 fz
-9	Spring	7890-06	24-10 775
-10	Bracket (4)		24-10 688
-11	Pin		24-10 522:2
-12	Leaf spring (4)		24-10 690
-13	Support studs (2)		24-10 863
-13,1	Washers		24-10 865:1
-13,2	Washers		24-10 865:2
-14	Stop screw		S6SS 5 x 5 fz
-15	Stopper		24-10 723
-16	Guide		24-10 691
-16,1	Screws		LKCS 3 x 5 fz
-17	Ball		Stålkula ϕ 3
-18	Spring		24-10 695
-19	Set screw		P6SS 5 x 8 fz
-20	Screw		EC6S 5 x 8 fz
-20,1	Washer		BRB 5,3 x 10 fz
-21	Clamping head		22-17 03
-22	Pin		24-10 522:1
-23	Scoring selector		24-10 689
-24	Runner (4)		24-10 518
-25	Pin		24-10 522:2
-26	Scoring shaft		23-22 42
-27	Grip		24-10 523
-28	Retainer		SgA6



GLASS SETTING ASSEMBLY

78-3

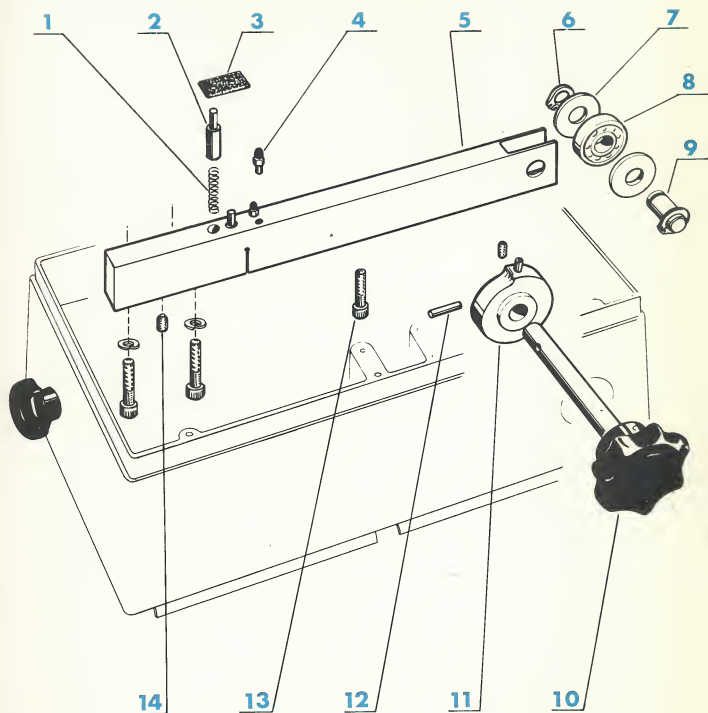
Spare Part No.	Name of Part	Catalogue No.	Internal No.	
78-3-1	Guide holder "See also 14-17"		14-10 738	
-1,1	Screws		ECS 5 x 8 fz	
-1,2	Washers		BRB 5,3 x 10 fz	
-2	Rear glass holder		24-10 610	
-3	Locking screw		24-10 613	
-3,1	Washer		24-10 741	
-4	Glass strip support plate		24-10 703	
-5	Dowel Pins		24-10 700	
-6	Retainers		SgA5	
-7	Springs		24-10 746	
-8	Spring sockets		24-10 699	
-9	Guide plate		24-10 615	
-9,1	Locking knob		14-10 729	
-9,2	Washer		BRB 6,4 x 12 fn msg.	
-10	Angle setting plate (5)	7890-03	24-10 662	
-10,1	Screws		LKCS 4 x 8 fz	
-11	Spring		24-11 006	
-11,1	Screw		LKCS 3 x 5 fz	
-12	Shaft with joint		34-10 728	
-12,1	Shaft		24-10 727	
-12,2	Clamping pins		FRP 2 x 14	
-12,3	Lock screws		PSS 3 x 4 fz	
-12,4	Joint		24-10 724	
-12,5	Angle bracket		24-10 656	
-12,6	Screws		ECS 4 x 8 fz	
-12,7	Lock washers		FBB 4,1	
-13	Disengage knob		34-10 726	
-14	Slit studs		24-10 612	
-15	Guides		24-12 054	
-16	Adjustment knobs		24-11 429	
-17	Locking screws		24-10 613	
-18	Damping device	7804A	14-11 781, 04-11 782	
-19	Damping pad (7)	7894-02	24-11 783, 04-12 610	



BREAKING ASSEMBLY

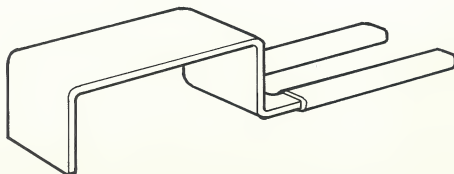
78-4

Spare Part No.	Name of Part	Catalogue No.	Internal No.	
78-4-1	Springs		24-10 748	
-2	Arresting studs		24-10 625	
-3	Damper		24-10 756	
-4	Breaking pins		24-10 708	
-5	Breaking arm		22-17 00, 04-10 628	
-5,1	Screws		EC6S 10 x 40	
-5,2	Lock washers		BRB 10,5 x 18 fz	
-6	Retainers		SgA 12 fz	
-7	Cover washers		24-10 627	
-8	Ball bearing		SKF 6201	
-9	Shaft		24-10 539	
-10	Breaking knob		14-10 672	
-11	Eccentric cam		34-10 732	
-11,1	Lock screw		SK6SS 4 x 5 fz	
-12	Clamping pin		FRP 3 x 22	
-13	Adjusting screw		EC6S 12 x 40	
-14	Set screw		SK6SS 5 x 12 fz	



ACCESSORIES

Spare Part No.	Name of Part	Catalogue No.	Internal No.	
78-5-1	Fork See Figure below	7802A	34-10 862, 04-10 880	
-2	Glass strips, thickness 6,4 mm 25 x 400 mm (pkt of 30)	7890-04	12-17 14, 04-10 874	
-3	38 x 400 mm (pkt of 20)	7890-05	12-17 15, 04-10 875	
-4	Dust Cover	7803A	23-23 09, 04-10 990	
-5	Tool set	7896-01	04-10 883	
-5,1	Wrench 6 mm	7891-01	Gedore, DIN 894, NV 6	
-5,2	Allen Wrench 2,5 mm	7891-02	Unbrako Nr. W3	
-6	Operation Instruction English	I-7800B	I-7800B-E05, E13	
-7	German		I-7800B-T05, T13	
-8	French		I-7800B-F05, F13	
-9	Shipping container	7899-01	21-552, 04-11 136	



ADJUSTMENT AND MAINTENANCE NOTES

The purpose of this section is to describe disassembly and assembly of the most critical parts of the KnifeMaker and explain technical adjustments. There is little that can go wrong if the instrument is not severely wrenched or dropped. Watch for the following normal servicing:

A. Glass chips should occasionally be cleaned away, not only to preserve neatness and as a matter of courtesy to subsequent users, but also to prevent possible misalignment of glass squares caused by the chips laying on critical parts. Don't worry about chips and dust falling inside the instrument through openings in the cover plate - it will not impede operation.

B. Sliding surfaces should be lightly coated with molycote. We stress "lightly" because there is a tendency to overgrease. The sliding movement of the Clamping Head on the Bracket is the part to watch. The surfaces should not be dry. Wipe the surfaces clean before applying fresh molycote.

C. Keep the Operation Instructions, and even this Spare Part Catalogue, in the recess provided in the KnifeMaker (78-0-7). Everyone in the laboratory then can easily find these manuals.

- (1) Occasionally the Cutter wheel should be replaced.
If you find that scoring becomes coarse or difficult even after adjusting the pressure on the wheel (See (3)), it probably means the wheel should be replaced. A spare wheel is included with the basic instrument and additional wheels can be ordered (Spare Part number, 78-2-5).

Replacement of Cutter Wheel

Refer to drawing 78-2

Remove Clamping head as follows:

Set symbol  on Scoring Shaft 26 upwards.

Hold Locking Lever 4 tilted about 45° towards operator and remove Clamping Head 78-2-0

Hold Clamping Head upside down and press down Cutter Wheel Holder 7 with thumb and remove Locking Pin 2.

(If it is difficult to press down the Holder 7 loosen Pressure Adjusting Screw 6 by turning it counter-clockwise).

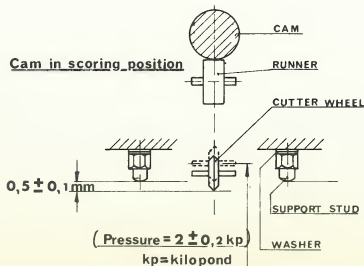
Place Clamping Head on table and push out Cutter Wheel's shaft 4 with, for example, a paper clip and remove Cutter Wheel 5.

Insert new Cutter Wheel and new shaft.

Replace pin 2.

Replace Clamping Head and make a test scoring.

- (2) Scoring Shaft 26, Cutter Wheel 5 and Support Studs 13
Relative positions when scoring.



(3) Adjustment of scoring pressure

If the score in the glass becomes too deep or too faint, the pressure on the Cutter Wheel must be adjusted as follows:
Hold Locking Lever 4 tilted about 45° towards operator and Remove Clamping Head (78-2) and place it upside down on a table.

Insert Allen Wrench (78-5-5,2) into Pressure Adjusting Screw 6 and adjust spring pressure as follows:

If scoring pressure is too great, turn wrench counter - clockwise, e.g., one turn.

If scoring pressure is too small, turn wrench clockwise, e.g., one turn.

Replace Clamping Head and make a test scoring.

(4) Removal of Runner or Leaf spring of Clamping Head

Refer to drawing 78-2

Remove Clamping Head as follows:

Set symbol  on Scoring Shaft 26 upwards.

Hold Locking Lever 4 tilted about 45° towards operator and remove Clamping Head and place it upside down on a table.

Remove Set Screw 14 and Stopper 15

"Pull out" Scoring Shaft 26 until Pin 22 is aligned with hole in Clamping Head 21

Push out Pin 22

Remove Bracket 10

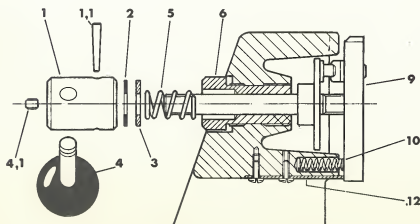
The Runner and Leaf Spring can now be picked out.

Replacement of Angle Setting Plate

- (5) Refer to drawing 78-3,
 Remove Locking Knob 9, 1 Guide Plate 9.
 Screws 10, 1 and Angle Setting Plate 10.
 Apply new Angle Setting Plate and insert the two Screws but
 do not tighten them yet.
 Adjust the plate so that the lines $70^{\circ}/110^{\circ}$ and 90° coincide
 with the dots on the Cover Plate (78-0-8)
 Tighten the Screws
 Replace Guide Plate and Knob
 Be careful not to lose Washer 9, 2

(6) A. Disassembly of locking mechanism

- Refer to drawing 78-7
 Hold Locking Lever 4 tilted about 45° towards
 operator and remove Clamping Head.
 Swing Locking Lever 4 to lock position as shown in figure 78-8.
 Push out Tapered Pin 1, 1.
 Loosen Lock Screw 4, 1 and remove Locking Lever 4.
 Unscrew Hub 1.
 Remove Friction Washer 2, Washer 3 and Spring 5.
 Pull out Pressure Assembly 9 and Spring 10.
 Remove Cover Screw 11, 1 and loosen Set Screw 11.
 Unscrew Adjusting Sleeve 6.
 Assembling on next page.



(6)
cont.

B. Assembling of locking mechanism.

Grease sliding surfaces lightly with Molycote.

Tighten Adjusting Sleeve 6.

Push in Pressure Assembly 9. See figure 78-7

Replace Spring 10

NOTE: Make sure that Leaf Spring 12, is in recess of stud.

Replace Spring 5.

Put metal Washer 3 and then fibre Friction Washer 2 onto axis of Pressure Assembly 9.

While pushing Pressure Assembly 9 to the left, screw on Hub 1 so far, that the hole in the shaft coincides with the hole in the axis, then push in Taper Pin 1,1.

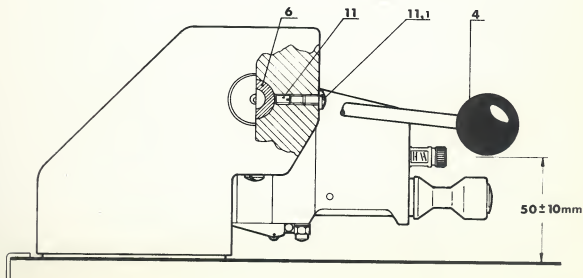
Replace Locking Lever 4 and lock with Lock Screw 4,1.

Replace Clamping Head.

Swing lever to horizontal position (black ball pointing towards operator) and hold it steady while turning Adjusting Sleeve 6 towards Hub 1.

Screw in the Set Screw 11 and tighten it securely.

Replace Cover Screw 11,1.



(7) Adjustment or replacement of Damping Pad

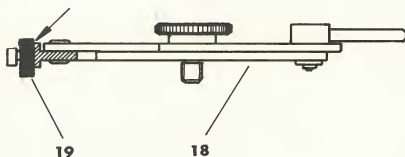
Refer to drawing 78-9

Damping Pad 19 will have to be replaced when it has become completely worn from use.

However, when one part of the pad is worn, simply rotate the pad to expose a new surface for the edge of the glass square.

If you have to replace the Damping Pad a spare pad is included with the basic instrument and additional pad can be ordered

(Spare part number, 78-3-19)





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